

NCR-19-7651



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400203-K
Job Sheet 194194



Part No: RBT400203-K

Job Qty: 4 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400203 Rev.5 IPP Rev. A 19.01.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	5/31/19		0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	5/31/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 9 - 10		
120	QC 5	4 pcs	5/31/19		0.00	0.00	QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S189579



Part: RBT400203-K

Job No: 194194

Serial No/Batch: S189579

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/12/19

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https://www.plexonline.com/e0f634a0-9ee1-4c71-9b6d-7710b7e95a15/Plexus_Control/Report_View/2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 2/3

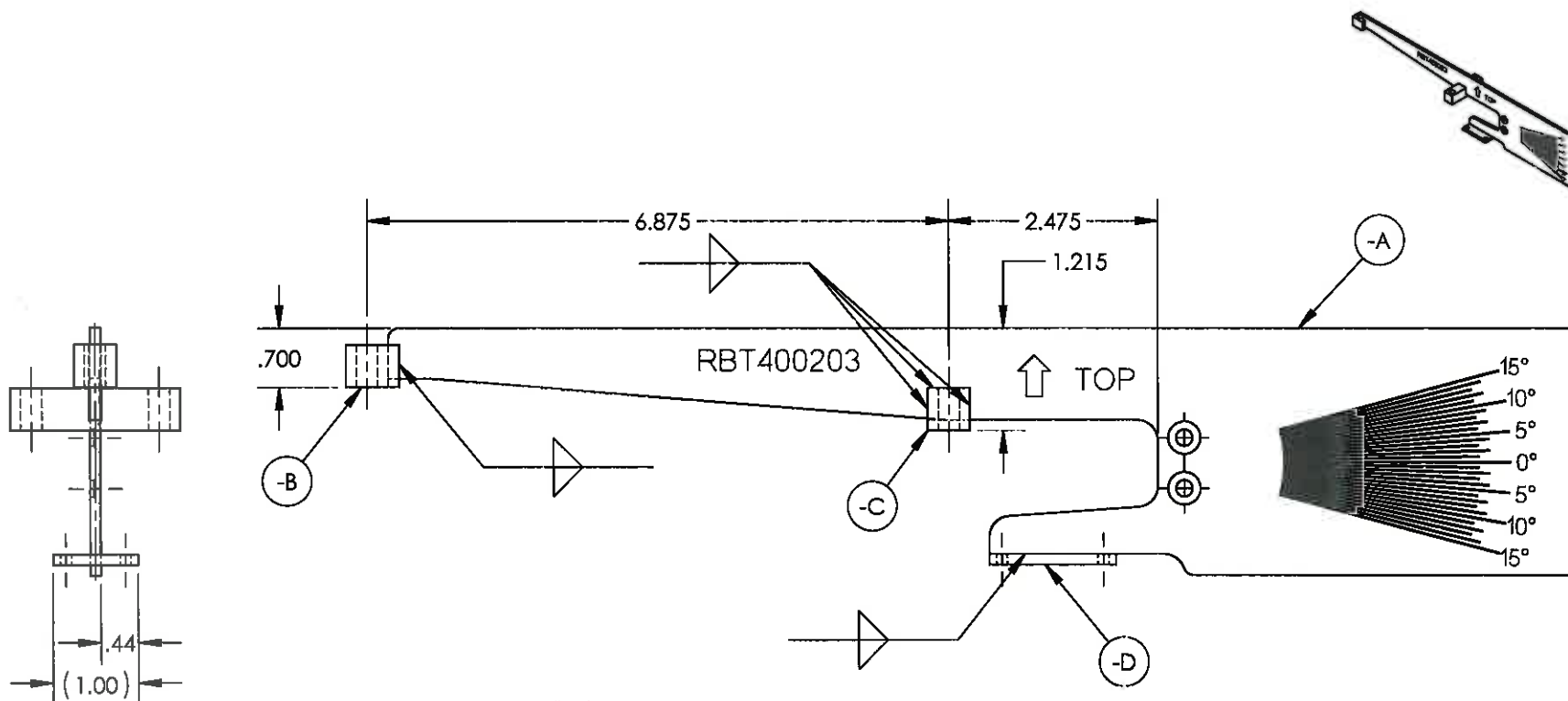
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	4 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	DAS 53
				QC 21 - SA - 70	
				QC 21 - SA - 53	JUN 25 2019
Part Op 100 - Weld as per drawing using DT10512. Descriptions: 160 - Issue P/O; <u>43713</u> -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 170 - Certificate of Conformity is required					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBT400203-A	Gauge Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5163123	
RBT400203-B	End Brg. Pt.	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5161549	
RBT400203-C	Dbl Brg.Pt.	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5161796	
RBT400203-D	Support Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5163142	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Large Fab - Welded Assy-1	RBT400203-A	4	4	0	
	RBT400203-B	4	9	0	
	RBT400203-C	4	10	0	
	RBT400203-D	4	10	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3A		CH'D WELDMENT FROM -A WELDMENT, DELETED NOTES 1, 2, & 3, CH'D FINISH FROM P.C. SAFETY YELLOW PER R.W.	8/11/2011	RJC	RW
4		ADDED .515 DIM.	2/13/2013	BIM	SE
5	16-0027	-K CH'D DIM WAS 1.00 IS (1.00). DELETED DIMS .515, .250, .250, 2.000, 5.00. ADDED DIM .44.	2/9/2016	DPD	SM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194194 HCS
1904-26

(-K)

WELDMENT GAUGE PLATE

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400203-K	REV 5
MAT'L TREAT FINISH RED ANODIZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
SPEC MIL-A-8825, TYPE II, CLASS II	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	BELL 206
APPROVED: MACKOVJAK	
SCALE 1:2	DATE 1/10/2002
SHEET 2 OF 11	



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043713



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043713

PO Date: 6/13/19

Due Date: 6/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195895	D2224	Rappel Anchor Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O: Red Anodize as per Dwg D2224 MIL-A-8625	Received	-	6/27/19	10 pcs	10 pcs	0 pcs	\$9.37/pcs	\$0.00
2	196219	RBD29904	Hoist Adapter "D" Model -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	6/27/19	1 pcs	0 pcs	1 pcs	\$9.37/pcs	\$9.37
3	194194	RBT400203-K	Weldment -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	6/27/19	3 pcs	0 pcs	3 pcs	\$9.37/pcs	\$28.11

JUN 20 2019

DAS
61
8-89

DP



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PURCHASE ORDER

POHB043713



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193195	RBE350A94-3301-00	Tail Rotor Accelerator Support -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Received	-	6/27/19	17 pcs	17 pcs	0 pcs	\$9.38/pcs	\$0.00
Grand Total:											\$37.48

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/20/19 8:37 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918025

Date: 19-Jun-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
3 ea	Part: RBT400203-K Weldment Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 25332 PO: POHB043713	Rev: 5 61 9-89	Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUN 19 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED JUN 19 2019 DART AEROSPACE LTD. Made in Canada.			

Entered: 24 ^{DAS 43 9-89} Date: 12 June 2019

ZK Oct 30/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7651

Route update only ☐

Job: <u>RBT 400203-K</u> Part No. <u>RBT 400203-A</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>12 June 2019</u>		Sequence #: <u>110</u>		QTY Affected: <u>3</u>		MRB (QSI042) DAS 55 9-89 <u>[Signature]</u>	
Description Work Order Deviation				Disposition		Completed By <u>[Signature]</u> DAS 43 9-89 Lead hand / Supervisor <u>[Signature]</u> DAS 24 9-89 JUN 12 2019 QC / QA Coordinator <u>[Signature]</u> DAS 55 9-89	
<u>- found at inspection engraving on part DT RBT 400203-A is too deep.</u>				<u>- scrap and destroy.</u> <u>Part DT RBT 400203-A S163123</u> <u>The engraving is too deep.</u>			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☒ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					